

Date: Thursday, 6/28/2007 2:21:39 PM
 User: Kim Johnston

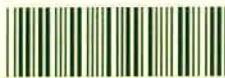
Process Sheet

SP/17

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	MOUNTING LUG	
Job Number	33250				
Estimate Number	10255				
P.O. Number	N/A		Part Number	D22301	
This Issue	6/28/2007	S.O. No.	Drawing Number	D2230 REV F	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A	Type	Drawing Revision	F	
Previous Run	32163		Material	N/A	
Written By			Due Date	7/25/2007	
Checked & Approved By	<i>JG 07.06.28</i>		Qty:	500	Um: Each
Comment	Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D2423	Lug Extrusion
Comment: Qty.: 0.0717 f(s)/Unit Total : 35.8575 f(s) Lug Extrusion D2423 Extrusion Batch: <u>30062</u>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch: <u>Machine per drawing D2230 rev F</u> C207/07/04 (500)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC5	SECOND CHECK
Comment: SECOND CHECK <u>Inspect Level 5</u> <u>osp019</u> <u>20070717</u> <u>i61</u> <u>Counted</u>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/07/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/28/2007 2:21:40 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 33250

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1



HAND FINISHING RESOURCE #1

(161X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.d

07/07/23

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ES 07/07/25 (161)

8.0 POWDER COATING

POWDER COATING

*m 105068*

(161)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

BR/m.d/07-07-25

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

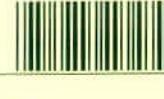
*FZ*

07/07/25 (16)

Comment: INSPECT POWDER COAT

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EPA 07/07/27 (161)

(16)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

S 07/07/30

Job Completion

*Apr 07 -07-30*

1

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

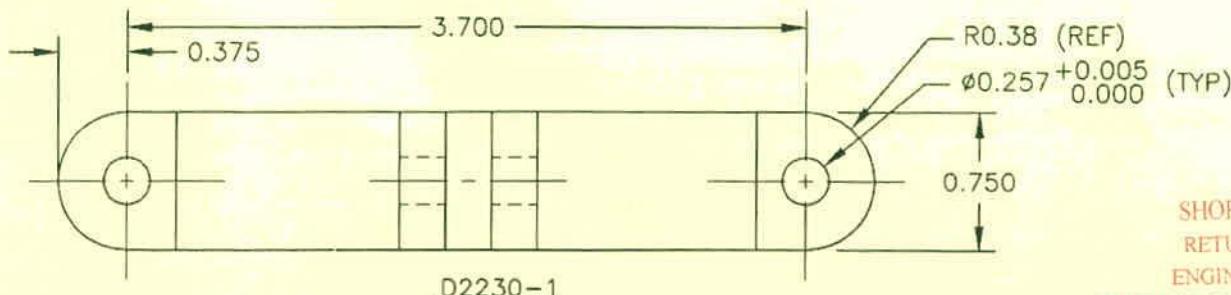
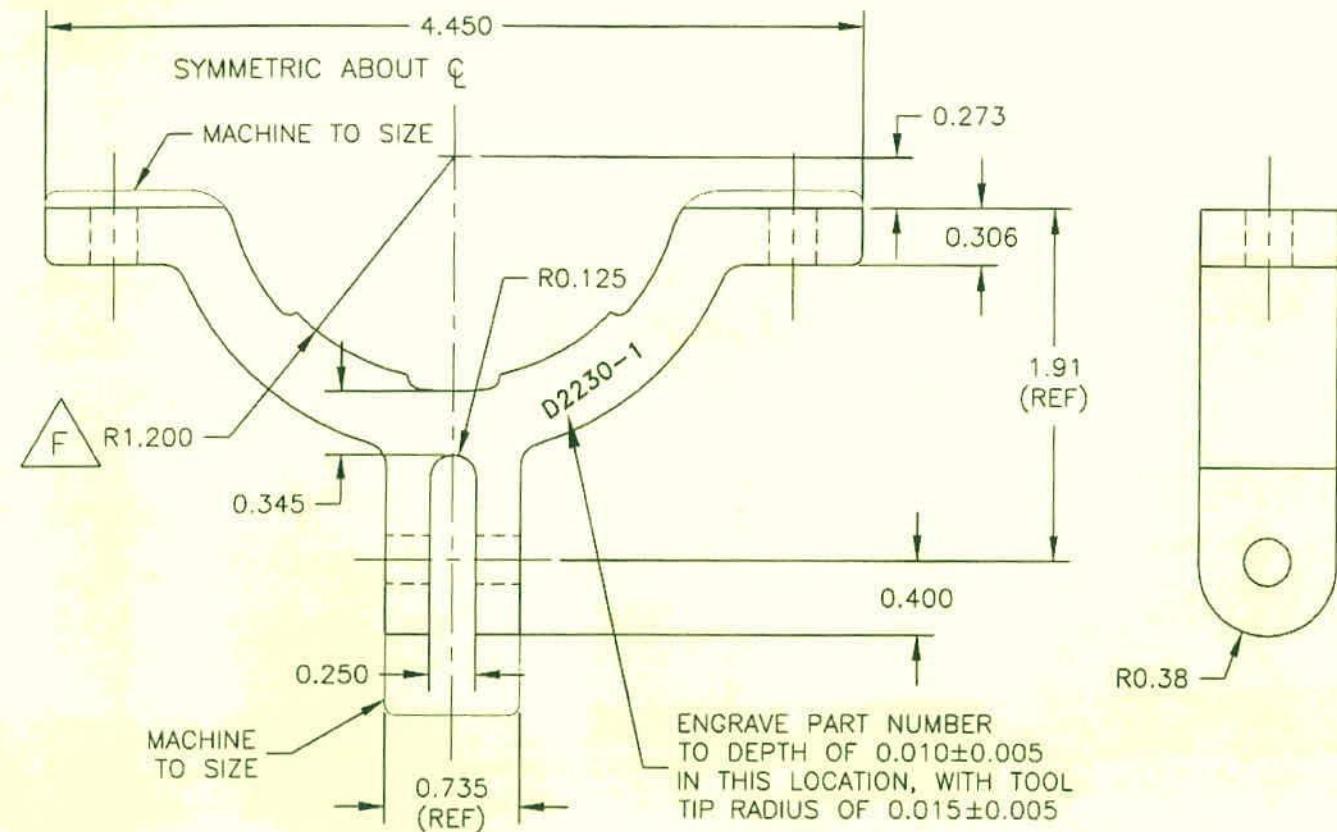
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		REV. F SHEET 1 OF 2
99.12.13		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED

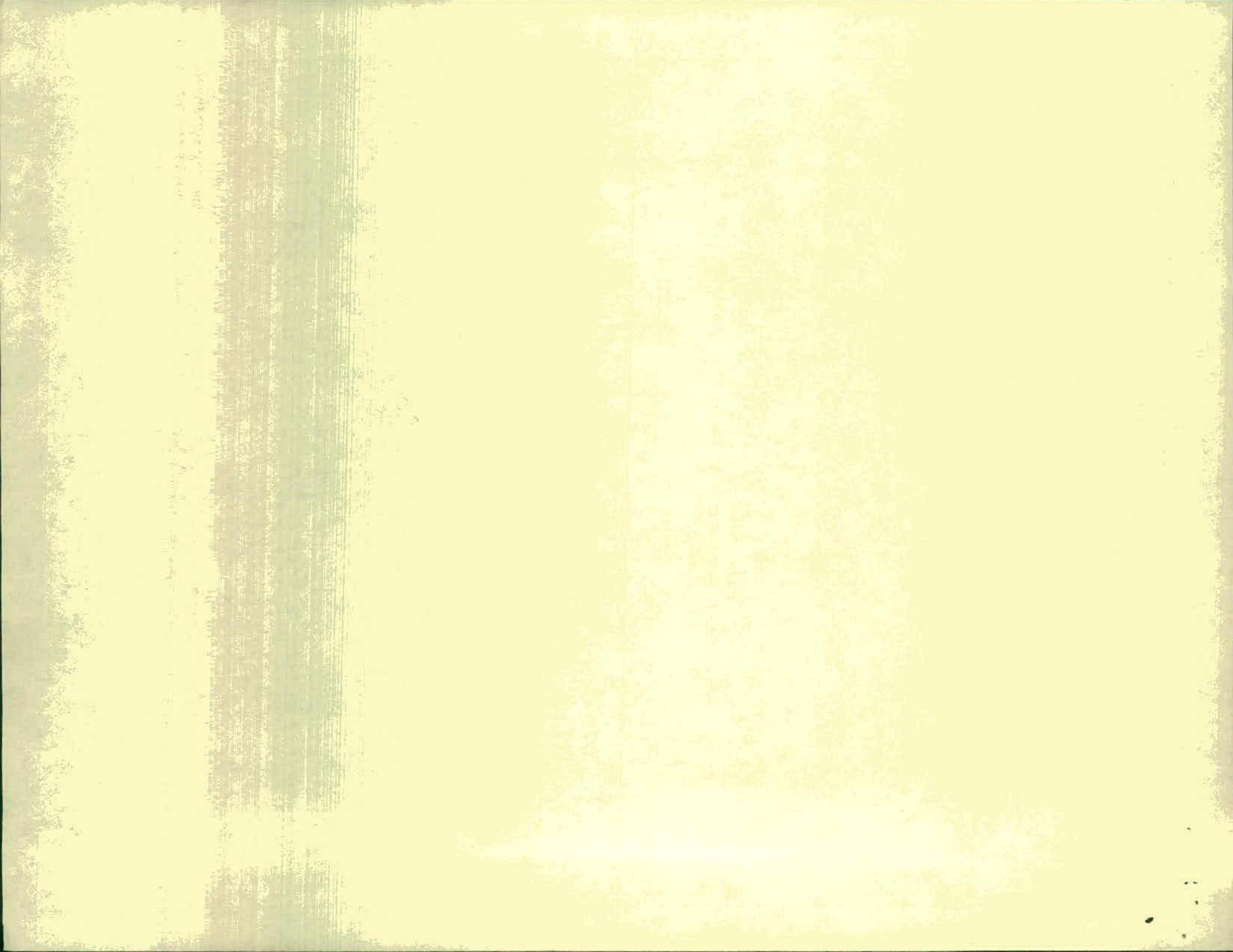
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000–0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

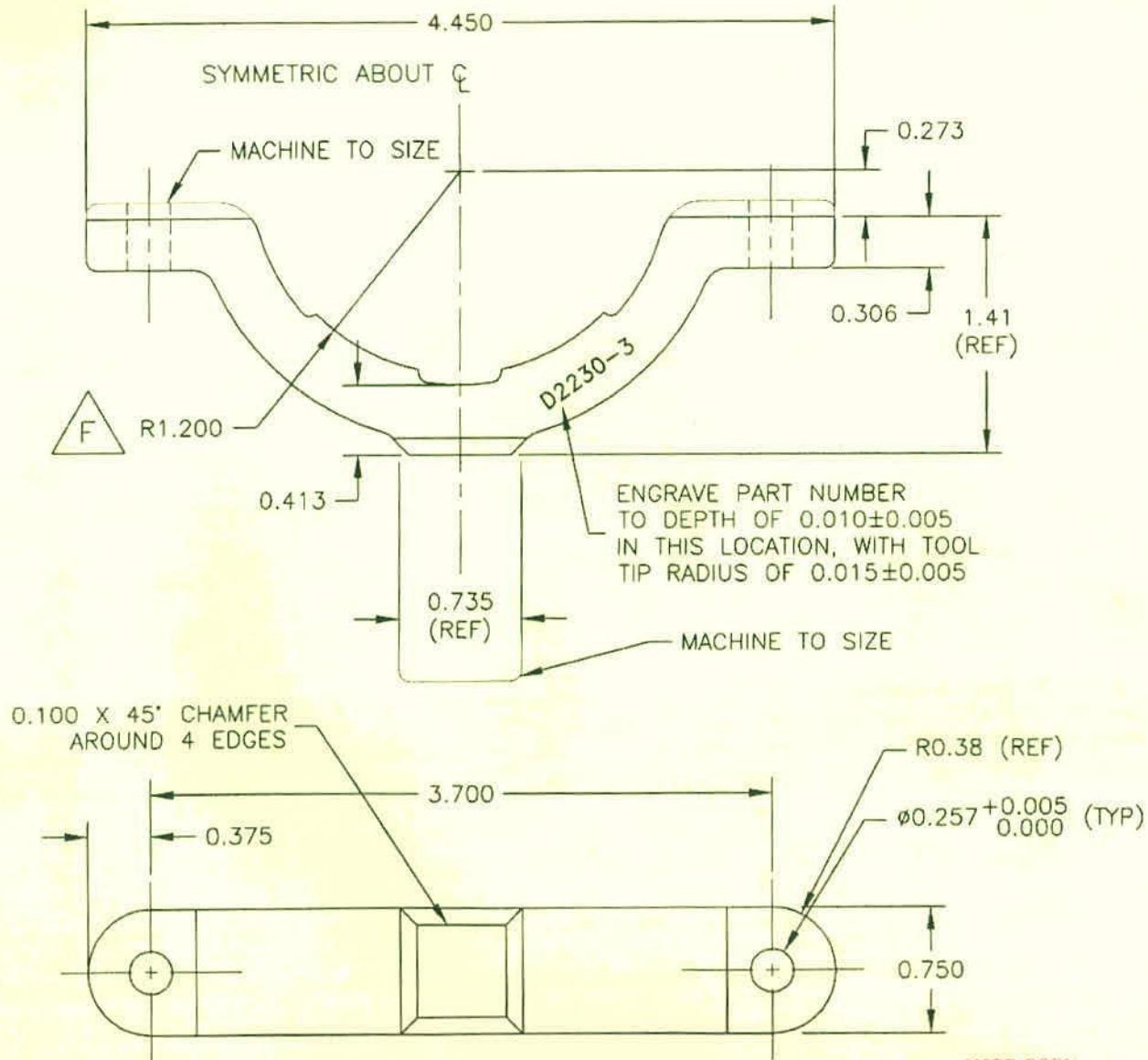
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33250

3.441
259
3708



DART

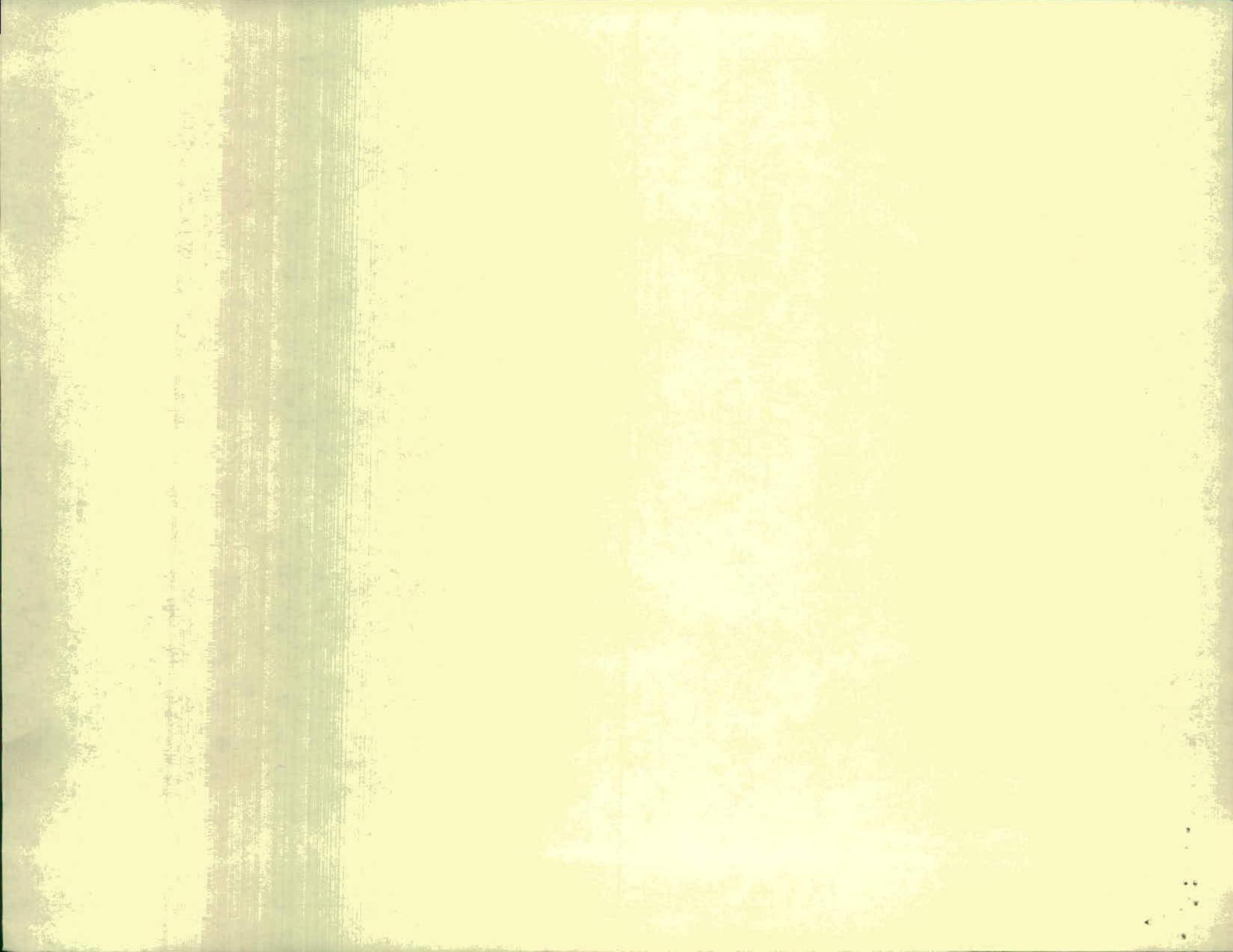
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F
DATE		TITLE MOUNTING LUG SHEET 2 OF 2
99.12.13		SCALE 1:1

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33250



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

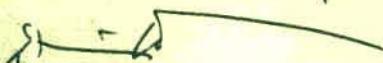
SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
160	D2230-1	Mounting Lug	4091

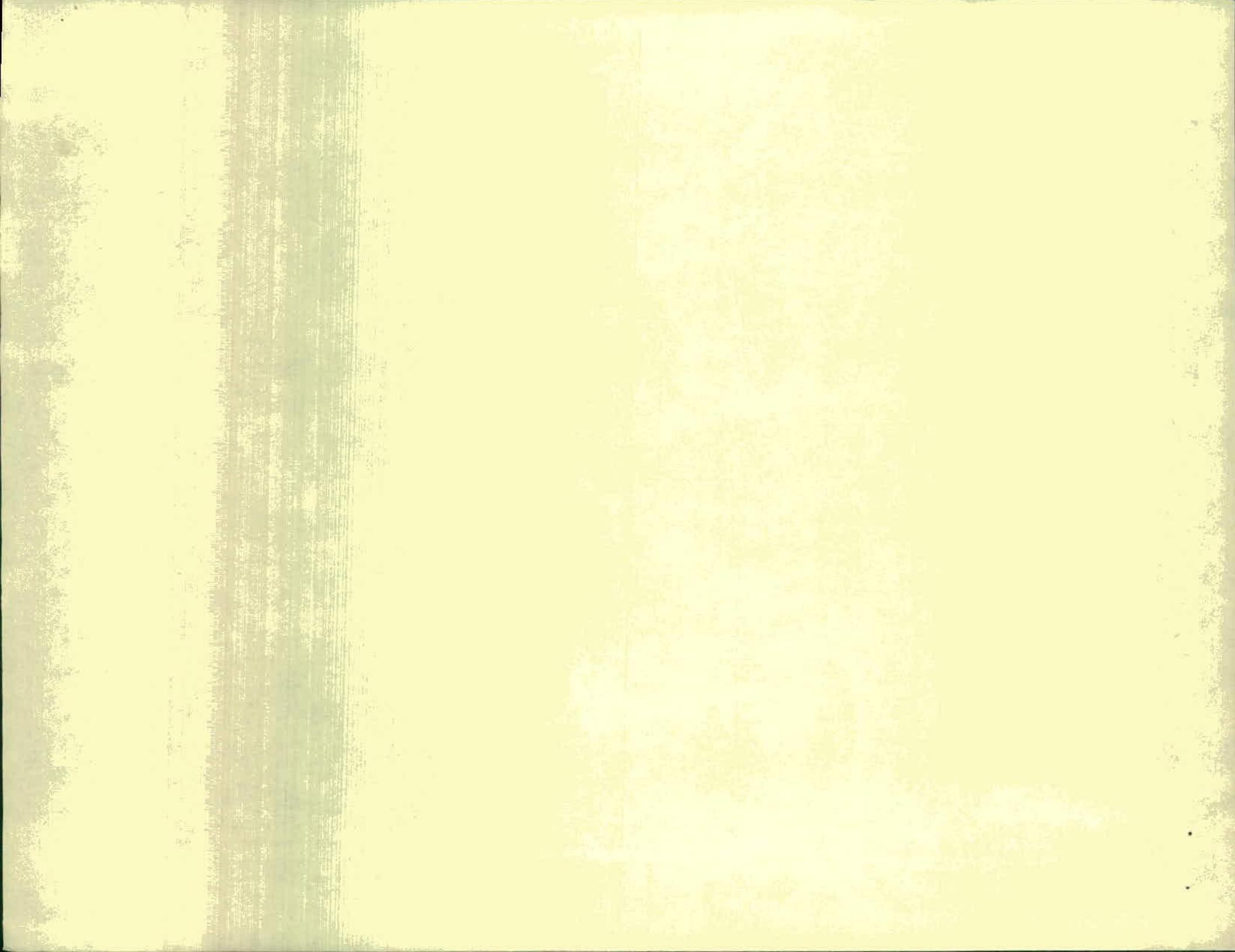
MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Denise Robinson

Vankleek Hill, July 12, 2007



METEC METAL TECHNOLOGY INC.

20 Terry Fox Drive
 Vankleek Hill, Ontario K0B 1R0
 Tel: (613) 678-3957
 Fax: (613) 678-3956

Delivery Slip No.: 16003
Date: Jul 12, 2007
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.:	Sold By:
4091 Dcn	Jul 12, 2007
Shipped By:	Ship Date:

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1	Mounting Lug	Each	500	160	340
MATERIAL 2423 B30062 supplied by DART					
D3235-1	Mounting Lug	Each	600		600
D3338-1	Mounting Lug	Each	20		20
D3394-3	Lug	Each	40		40

Received by _____	Thank you for your order!
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